



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5155-11
Job Sheet 191832



Part No: D5155-11

Job Qty: 6 pcs

Part Name: Co-Pilot Collective Head (212)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV.A NEW ISSUE JFS 15/01/14 VERIFIED BY: JLM IPP REV:B 15.07.02 AS PER DWG
REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	6 pcs	3/29/19	3/29/19	0.00	0.01	Bandsaw - 1	67
110	HAAS 5 Axis - B4B	6 pcs	3/29/19	3/29/19	0.09	10.17	HAAS - 5 - B4B	19-04-07
120	QC 1	6 pcs	3/29/19	3/29/19	0.00	0.00	QC 1 - 14	19-04-07
							QC 1 - 35	
							QC 1 - 8	
							QC 1 - 9	
130	QC 8	6 pcs	3/29/19	3/29/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
150	Outsource - 4 - Anodize	6 pcs	3/29/19	3/29/19	0.00	0.00		04/12/2019
155	Packaging 2-1 - Receive - B4B	6 pcs	3/29/19	3/29/19	0.00	0.00	Packaging 2 - 1 - B4B	



Container No: S169074



Part: D5155-11

Job No: 191832

Serial No/Batch: S169074

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/03/19

Plex 3/11/19 8:10 AM Dart.lajeunesse.marie

				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP APR 22 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
158	QC 5	6 pcs	3/29/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
160	Packaging 3-1 - Stock - B4B	6 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B

Plex 3/11/19 8:10 AM Dart.lajeunesse.marie

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	54375 APR 22 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	6 pcs	3/29/19	0.00 0.00	QC 21 - SA - 21	DAE
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-06 APR 22 2019
Part Op 100 - CUT BLANK AT 4.900" Descriptions: 110 - (HAAS CNC vertical machine #5), MACHINE AS PER DWG & FOLIO FB349/ D5155-11 120 - (QC1- Inspection performed by CMM), Inspect on CMM as per folio CMMA033. 130 - (QC8- Inspect parts - second check) 150 - (Outsource process-Anodize per QSI017 4.1.10.1), ISSUE P/O: 043190 ANODIZE BLACK AS PER MIL SPEC AND DWG C OF CO IS REQUIRED 155 - (Receive & Inspect for Damage & Mat'l Certs) 158 - (QC5- Inspect part completeness to step on W/O) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B2.500X03.500	6061-T6 Bar 2.50 X 3.50	2.4540 ft (409 ea) 2.491 .4135	100-Bandsaw - 1	5166898	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B2.500X03.500	2	4	0	
Part Specifications					
Specifications could not be found.					

Plex 3/11/19 8:10 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	191832
Description: Co-Pilot Collective Head (212)		Part Number:	D5155-11
Inspection Dwg: D5155 Rev: B		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.800	+0.010/-0.000	2.802	✓		Height gauge	
1.83	+/-0.030	1.830	✓		"	
R0.19	+/-0.030	.190	✓		Rad gauge	
21°	+/-0.5°	21°	✓		Protractor	
0.227	+/-0.010	.228	✓		Height gauge	
1.850	+/-0.010	1.845	✓		"	
Ø0.125 x 0.350	+0.004/-0.001 x +/-0.010	.126 x .350	✓		gauge Pin/SL10 Vern	
21°	+/-0.5°	21°	✓		Protractor	
2.547	+/-0.005	2.549	✓		SL10 Vern	
0.35	+/-0.030	.358	✓		"	
R0.25	+/-0.030	.250	✓		Rad gauge	
0.35	+/-0.030	.344	✓		SL10 Vern	
0.06	+/-0.030	.061	✓		"	
0.33	+/-0.030	.328	✓		"	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.500	+/-0.010	1.500	✓		Height gauge	
Ø0.150	+0.005/-0.001	.152	✓		"	
1.450	+/-0.010	1.449	✓		"	
R0.30	+/-0.030	.300	✓		Rad gauge	
R0.03	+/-0.030	.032	✓		"	
0.100	+/-0.010	.098	✓		SL10	
3.000	+/-0.010	3.001	✓		"	
0.59	+/-0.030	.590	✓		"	
1.82	+/-0.030	1.820	✓		"	
R0.30	+/-0.030	.300	✓		Rad gauge	
R0.25	+/-0.030	.250	✓		"	
Ø0.150	+0.005/-0.001	.152	✓		SL10	
R0.25	+/-0.030	.250	✓		Rad gauge	
2.400	+/-0.005	2.400	✓		SL10 Vern	
0.300	+/-0.010	.298	✓			
1.450	+/-0.010	1.451	✓			
1.750	+/-0.010	1.747	✓			
Ø0.150	+0.005/-0.001	.152	✓			
2.70	+/-0.030	2.701	✓			
2.500	+/-0.010	2.502	✓			
2.20	+/-0.030	2.200	✓			
R0.30	+/-0.030	.300	✓		Rad gauge	

DART AEROSPACE LTD		Work Order:	191832
Description: Co-Pilot Collective Head (212)		Part Number:	D5155-11
Inspection Dwg: D5155 Rev: B		Page 2 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.25	+/-0.030	.250	✓		Rail	gauge
0.70	+/-0.030	.700	✓		SLIO	vern
0.20	+/-0.030	.200	✓			
4.700	+/-0.010	4.700	✓			
1.350	+/-0.010	1.347	✓			

Measured by:	DAS 20 9-89	Checked by:	DAS 52 9-89	QC Inspector:	
Date:	19-04-06	Date:	19/04/09	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	15.06.22	New Issue	KJ	
B	16.01.20	Dimensions updated per Dwg Rev B	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043190



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043190

PO Date: 4/12/19

Due Date: 4/18/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191529	RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed - X8	-	4/18/19	8 pcs	0 pcs	8 pcs	\$5.00/pcs	\$40.00

Line Item Note ** NEED BACK APRIL 18,2019 **

2	188431	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed - X10	-	4/18/19	10 pcs	0 pcs	10 pcs	\$5.00/pcs	\$50.00
---	--------	---------------------	--	---------------------	---	---------	--------	-------	--------	------------	---------

Line Item Note ** NEED BACK APRIL 18,2019 **



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043190



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191832	D5155-11	Co-Pilot Collective Head (212) : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1), ISSUE P/O: ANODIZE BLACK AS PER MIL SPEC AND DWG C OF CO IS REQUIRED	Firmed	-	4/18/19	6 pcs	0 pcs	6 pcs	\$5.00/pcs	\$30.00
Line Item Note ** NEED BACK APRIL 18,2019 **											
4	191282	RBW2805G00131-3G-1	Slide (Outsource process- Anodize per QSI017 4.1.10.1)-Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	4/18/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
Line Item Note ** NEED BACK APRIL 18,2019 **											
Grand Total:										\$240.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/15/19 11:26 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018485-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018485 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
17-Apr-2019		SPARTAKOS BOUNTOURIS		PO043190				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBE350A93-3205-00T Rev.	RBE350A93-3205-00T ANODIZE BLACK PER MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
2	RBE350A93-3302-02-5 Rev.	RBE350A93-3302-02-5 - ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	10	10	0	0	0
3	D5155-11 Rev.	D5155-11 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0
4	RBW2805G00131-3G-1 Rev.	RBW2805G00131-3G-1 01-ANO-CLEAR [ANODIZE CLEAR]	ANODIZE CH	6	6	0	0	0

DAS
40
9-89

Notes Additionnelles / Additional Notes

big box
small box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.